D3458-1

119278

Page 1

Work Order ID 119278

Wednesdav. May 14, 2014 10:08:47 AM

wea	nesaay	, May .	14,	201	4 10	1:08:4	/ AI
_	_						

Revision ID:	D3458-1			Accept	*N900	1040	1100)*	Setup	Start Stop	171	S1*
	Step Mounting 5/15/14 5/30/14	Start Qty: 30.00 Req'd Qty: 30.00	*30* *30*		Cust Item Customer					Stop	×N.	S2*
Approvals:	Process Pla	n:	Date: 14-5-14	Tooling: SPC (Y/N):		Date:			Run	Start Stop	^IV	R1* R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr			,							
D3458	Rev	A										
*100 *100* Waterjet FLOW CNC Waterjet		FLOW WATER JET Memo 1-Cut as per Dwg Rev: Prog Rev:	<u>A</u>	0.00			(30)			DAS 37 9-89	1
110 *1 1 		2-Deburr if r QC2- Inspect parts off many Memo	·	0.00			(36)			DAS 37 9-89	1: /
120 *1 7 1 * Q C Quality Control		QC8- Inspect parts - seco	nd check	0.00 Q S	ටර			<u>30</u>				

DOA:			Data						· (1) 章	er in the				•	
DQA:			. Date:			WORK ORDER NON-	-cc	ONFO	RMANCE / U		,_	ale Ondon con	data anki - [7	AEROSPACE
QA Closed:			Date:				_			VV	0	rk Order up	date only	_	
Mark Orda						DISPOSITION				AGAINST DE	EF	PARTMENT/	PROCESS		
Work Orde	:ı. -					Rework			Skid-tube	Crosstube	٦		Water Jet	٦	Engineering
Part N	in.					Scrap			Machining	Small Fab	1	Proc	d. Eng. Coor.	┨	Quality
	•				_	Use-as-is			noforming	Finishing	1	Rec/Stor	e/Packaging	٦	Other
NCR N	10.					Suspected Unapproved			Large Fab	Composite]		Supplier		
	•										 -			_	<u> </u>
Root					Desc	ription of work order update		nitial		tion	١	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	4	Date	Verification	4	QC Inspector
Design							ľ				1				
Doc/Data															
Equip/Tooling							•				1			ı	
Handling/Pre														١	
Material			ļ									İ			
Operator		4 -7												1	
Offset/Setup		37									ı			١	
Process														I	
Supplier			}												
Training											1				
Transport					ļ										
Unapproved							<u> </u>				⅃			\Box	
		٠, ٢٠					FA	ULT CA	rEGORY					_	
Landi	ng C	ear				General		-			_	Ī	_	_	
		Bending				Bend		Folio/F	rogram		-	Outside Dim		—₁	Pressure/Forced
		Centre N	ot Concei	ntric		BOM/Route	L	Grain			-	Over/Under	-	_	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire	Ļ	_	Part Incorred	-	_	Temperature/Cure
		Crimp/Ki	nk/Rinnle	/Wave		Burrs	1	Inspect	ion Incomplete/U	ngualified	ı	Part Lost/Mi	ssing		Weld

Part Moved Wrong Stock Pulled Instructions Incomplete/Unclear Cuffs Contamination Misaligned/off center Positioned Wrong Crushing Countersink Other Mislabeled Power Loss/Surge Cut Too Short Heat Treat Misread Inspection Strip in Tube Drawing Drill Holes Off-set Marks/Chatter Out of Calibration Turning Sequence Finish Fit/Function Out of Sequence Wave/Twist in Tube

3												
Work Ord Wednesday, Me				*119	1278*						Page	2
Item ID:	D3458-1			Accept	*N900	040	100) * s	Setup Sta	art *N	S1*	
Revision ID:								_	C4.		-	
Item Name:	Step Mounti	ng Plate							Sto	տ *//	S2*	
Start Date:	5/15/14	Start Qty: 30.00	*30)*	Cust Item 1	ID:						
Required Date	: 5/30/14	Req'd Qty: 30.00	*30		Customer:	•						
Reference:		•		1								
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:	_	R	Run Sta	~! <i>\</i> J	R1*	
	QC:		Date:	SPC (Y/N):	D	ate:			Sto	^{yp} *N	R2*	
Sequence ID/ Work Center	ID .	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
130				0.00								
130		Small Fab										
Small Fab		Memo	\) 0.00AS								
Small Fab		Deburr parts	perdwg D3458	27								
140		QC5- Inspect part comple	eteness to step on W/	O 0.00								
1 <i>4</i> 0												
QC		Memo		0.00								
Quality Control												

150

Identify as per dwg & Stock Location: WAOO 3 0.00

150 Packaging

Memo

0.00

*** STOCK IN STEP CELL***

DAS 28 9-89

MAY 2 0 2014

Packaging

DQA:			Date:				_						\)ART
QA Closed:			Date:			WORK ORDER NON	-C(ONFO	RMANCE / UI		ork Order up	odate only	_ 	AEROSPACE
			<u></u>			DISPOSITION				AGAINST DI	PARTMENT	/PROCESS		
Work Orde	er: ˌ									AGAM31 51	-, /-, (_	_	
						Rework]		Skid-tube	Crosstube	_	Water Jet	_	ineering
Part N	۷o.					Scrap			Machining	Small Fab	-	d. Eng. Coor.	_	Quality
						Use-as-is]	Thern	noforming	Finishing	Rec/Sto	re/Packaging	_	Other
NCR	۷o.					Suspected Unapproved]		Large Fab	Composite	J	Supplier	_	
Root				···-	Desc	ription of work order update		Initial	Act	ion	Sign &		$\overline{}$	
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Descr	ription	Date	Verification	Q	C Inspector
Design										-				
Doc/Data														
Equip/Tooling														
Handling/Pre			ļ											
Material												i		
Operator														
Offset/Setup														
Process														
Supplier														
Training														
Transport							İ							
Unapproved]		
							FA	ULT CA	TEGORY			·		
Landi	ng (Gear				General		,		_	-	_	_	
	Ш	Bending				Bend		Folio/F	Program	<u> </u>	Outside Dim) -	_	re/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		<u> </u>	Over/Under	-	Set-up	•
1	L	Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incorre	<u>+</u>	 '	erature/Cure
		Crimp/Kir	nk/Ripple,	/Wave		Burrs	_	Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld	
		Cuffs				Contamination		4	ions Incomplete/U	Jnclear	Part Moved	L	Wrong	g Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned V		_	
		Heat Trea	it			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		Inspection	n Strip in	Tube		Drawing		Misrea	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence		· · · · · · · · · · · · · · · · · · ·			

у												
Work Ord Wednesday, Ma				*110	7278*							Page 3
Item ID: Revision ID: Item Name:	D3458-1 Step Mounti	ng Plate		Accept	*N900	<u>0</u> 40	100)*	Setup	Start Stop	1 7	S1* S2*
Start Date: Required Date: Reference:	5/15/14 : 5/30/14	Start Qty: 30.00 Req'd Qty: 30.00	*30* *30*		Cust Item 1 Customer:	ID:					I W	. 12
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accer Qty	ot Rej Qty		Reject Number	Insp. Stamp
*160 *160*		QC21- Final Inspection -	Work Order Release	0.00						14/	6/6	21 1
QC		Memo		0.00						—	-t	

Quality Control

DQA:		_ Date:			-			_				`	T'A AG"
		5 .			WORK ORDER NON	-C(ONFO	RMANCE / UI		O		_	AEROSPACE
QA Closed:	···	Date:			•				VV	ork Order up	date only		
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	•	
VVOIR OTGET	·				Rework	1		Skid-tube	Crosstube	1	Water Jet		Engineering
Part No) <u>.</u>				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	\exists	Quality
					Use-as-is	1		noforming	Finishing	4	re/Packaging	╗	Other
NCR No).				Suspected Unapproved	1		Large Fab	Composite		Supplier		
						-							
Root				Desc	ription of work order update		Initial	Act	ion	Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	Ц.	QC Inspector
Design	_												
Doc/Data	4												
Equip/Tooling													
Handling/Pre	_												
Material			}									-	
Operator	_												
Offset/Setup	_			<u> </u>									
Process	_												
Supplier	4					1							
Training	4												
Transport	_												
Unapproved		1				<u> </u>	LUTCA	TECORY		<u></u>	· ·		
						FA	ULI CA	TEGORY		·			·
Landing	_				General Bend		Teolio/i	Program		Outside Dim	ensions [\neg _P	ressure/Forced
!	Bending	ot Concer	atric	\vdash	BOM/Route	-	Grain	rogram		Over/Under	- F	-	et-up
	Cracks	ot concer	itric	-	Broken/Damage/Defect	\vdash	Hardwa	are	<u> </u>	Part Incorre	-		emperature/Cure
 -	-	nk/Ripple	/\\/ava	-	Burrs	\vdash	4	ion Incomplete/Ur	agualified —	Part Lost/Mi		_	Veld
-	Cuffs	пкутарые	, wave		Contamination	\vdash	-{	tions Incomplete/l		Part Moved	-		Vrong Stock Pulled
-	Crushing			\vdash	Countersink	H	-	gned/off center	_	Positioned V	L Vrong	. لـــــ	
-	Heat Tre				Cut Too Short	\vdash	Mislab			Power Loss/		\Box_{c}	Other
-		on Strip in	Tube	\vdash	Drawing	\vdash	Misrea			⊿	· [
	Marks/C			-	Drill Holes		Off-set						
	⊣	Sequence			Finish		4	Calibration					
	_	vist in Tub			Fit/Function		-	Sequence					

Picklist Print													Page
Wednesday, May 14, 2	2014 10:08:55 A	M											1 age
Work Order ID: 1192	278		*	11927	' 2 *							-	
Parent Item: D345	58-1			D3458									
Parent Item Name: S	Step Mounting Plate	e	•	, 7, 1 -1 , 10	,- ,				tart Date: 5/15 Start Qty: 30.0		-	ed Date: 5/. ed Qty: 30	
Comments:	PP REV. A 05.1	2.13 NEW ISS	SUE 1	EC									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00		Purchased	No			100	f	18.9168	0.0427	2		········	
· ·													

Loc Qty

18.916842

18.916842

Loc Code

1.4

Location

MAT051

m128265

DQA:		Date:			•							`	
					WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE			_		AEROSPACE
QA Closed:		Date:							W	ork Order up	odate only		
Work Order:					DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS		
Work Order.					Rework			Skid-tube Crosstul	be		Water Jet	\neg	Engineering
Part No.					Scrap			Machining Small Fa	_	Pro	d. Eng. Coor.	1	Quality
					Use-as-is			noforming Finishi	ng		re/Packaging		Other
NCR No	•				Suspected Unapproved			Large Fab Composi	ite		Supplier		
Root				Desc	ription of work order update	ı	nitial	Action		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	4	QC Inspector
Design	4												
Doc/Data	-												
Equip/Tooling	4	İ											
Handling/Pre	4											ļ	
Material	-										,		
Operator	-											1	
Offset/Setup	1												
Process	-				•								
Supplier	-												
Training Transport	1												
Unapproved	1												
опарріочеа	1	l				FA	ULT CA	TEGORY					
Landing	Gear				General		, st			*****			
ľ	Bending				Bend	Г	Folio/F	Program		Outside Dim	ensions	P	ressure/Forced
	Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	S	et-up
	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí [emperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	^	/eld
	Cuffs				Contamination		Instruct	tions Incomplete/Unclear		Part Moved	Ĺ	\w	rong Stock Pulled
	Crushing				Countersink		Misali	gned/off center	_	Positioned V	Vrong	_	
	Heat Trea	at			Cut Too Short	L	Mislabe	eled		Power Loss/	Surge	0	ther
	Inspectio	n Strip in	Tube		Drawing		Misrea						
	Marks/Ch	natter			Drill Holes		Off-set						
	Turning S				Finish	L	4	Calibration					
	Wave/Tw	vist in Tub	oe .	- [Fit/Function		Out of	Sequence				_	

DART AEROSPACE LTD	Work Order:	119278
Description: Step Mounting Plate	Part Number:	D3458-1
Inspection Dwg: D3458 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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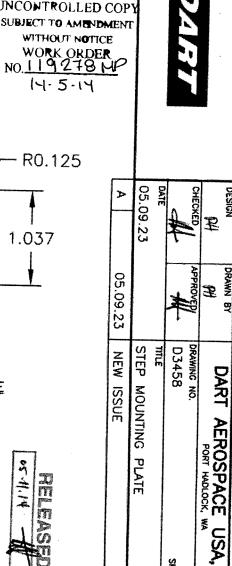
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.437	+/-0.010	0.437			V 5km-05	
3.080	+/-0.010	3.080				
0.703	+/-0.010	0.703				
R0.125	+/-0.010	0.125				
Ø0.257	+0.006/-0.001	0.259	//			
R0.500	+/-0.010	0.500				
2.041	+/-0.010	2041				
0.863	+/-0.010	0863				
			,			
-DA	s					

37 /	(DAS		
Measured by: 9-89 ma.	Audited by:	27	Prototype Approval:	N/A
Date: 14.05+18	Date: /	US121 V	Date:	N/A

Rev	Date	Change	Revised by	Approy∉d
Α	06.04.28	New Issue	KJ/JLM	\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\

SHEET 1 OF

≅C.



R0.386	0.257 (TYP) 0.703	SHOP COPY RETURN TO RETURN TO ENGINEERING UNCONTROLLEI SUBJECT TO AMENI WITHOUT NOTI WORK ORDI NO.119278	G O CO DME ICE ER H
0.867		R0.125	U5.09.23

D3458-1 STEP MOUNTING PLATE

D3458-3 STEP MOUNTING PLATE

D3458-1/-3 STEP MOUNTING PLATE

- MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK (REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE

R0.437

- 3) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)

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